October-22-12 3:17:25 PM

92068

Page 1

Item ID: Revision ID: Item Name:	647.1612 Splice Plate			Accept	*N900	040	100) *	Setup Sta	1/1	S1* S2*
Start Date: Required Date Reference:	22/10/2012 e: 05/11/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12		Cust Item Customer:	ID:				IN	
Approvals:		in: MLJ	1 '	22 Tooling: SPC (Y/N):		ate:			Run Sta	" 7	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
647.1600	N/C	!									
110				0.00				·· ·			
110 Waterjet FLOW CNC Water	-	Memo 1-Cut as per Dwg Rev:		0.00				16	٥		Jm 12-11-
JC 24.09	σ	Prog Rev:	4								
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
120 QC Quality Control		Memo		0.00				16	೦	: 	Jm12-11-1

											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORM	MANCE / UPDAT				ä
						<u> </u>			······································		QA Closed:	Date:	
Work Ord	er [.]					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ora						Rework	7		Skid-tube C	rosstube		Water Jet	Engineering
Part i	No.					Scrap	┪.			mall Fab	Pro	d. Eng. Coor.	Quality
i						Use-as-is	1		~ -	Finishing	1	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab Co	mposite		Supplier	
											-		
Root					Descri	ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Description	on	Date	Verification	QC Inspector
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Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш												
Process	Ц										1		
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Training	Ц												
Unapproved				<u></u>			1_						
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Landi	ng Gea					General	_	7		f	1		7
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	\vdash		t Concer	ntric to	o/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under	tolerance	Temperature/Cure
	⊢⊣	acks				Broken/Damaged	<u> </u>	⊣	on Incomplete		Part Incorre		Weld
	⊢		Crimped.			Burrs		Instruct	ions Incomplete/Uncle	ear	Part Lost/M	issing	Wrong Stock Pulled
1	l Ici	ıffs			1	Contamination		Mainte	enance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

October-22-12 3:17:25 PM

Packaging

Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	647.1612 Splice Plate 22/10/2012 : 05/11/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept **	Cust Item I		nn'	* 8	Setup Star Stop	1/1	S1* S2*
Approvals:	Process Pla	in:	Date:	Tooling:		nte:	· · · · · · · · · · · · · · · · · · ·	Į.	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00 PAS 15 0.00 /21/0	Tool ID	Tool # PI C	ode (Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* Outsource4 Outsource process -	Anodize	Outsource process-Anodiz . Memo Issue P/O: HARD ANOI	18336	0.00 0.00 S PER DWG.(SEE NOTE 3)	·			- ~-	Pl	12-11	-OG:
150 *150* Packaging		Receive & Inspect for Dan	nage & Mat'l Certs	0.00				/	Just	r luf ± 3	3 (4

												DQA:	Date:	,
NCR: Y	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
												QA Closed:	Date:	
Vork Orde	ır.						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
VOIK OIU	:1.					1	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					١	Scrap			Machining	Small Fab	Prod	l. Eng. Coor.	Quality
	•					١	Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	10.						Work Order Update			Large Fab	Composite]	Supplier	
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Root		Date	Step	Qty	Desc		tion of work order update Non-conformance	ļ	nitial ief Eng	Acti Descr		Sign & Date	Verification	QC Inspector
Cause oc/Data		Date	step	Qty		01	Non-comormance	CII	iei Liig	Desci	iption	Date	vermeation	QC IIISPECTOI
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		Bending					Bend		Grain			Ovalized	L	Pressure/Forced
		Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorred	t	Weld
		Crushed/C	Crimped.				Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	enance		Part Moved		
		Heat Treat	t				Countersink		Mislabe	eled		Positioned V	/rong	_
		Inspection		Tube			Cut Too Short		Misread	t		Power Loss/	Surge	Other
		Ripples in	Bend		L	\sqcup	Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [╝	Drawing		Out of (Calibration				
		Turning Se	equence				Finish		Out of 9	Sequence				
		Wave/Twi	ist in Tub	oe .		- [Folio		Outside	Dimensions			· · · · · · · · · · · · · · · · · · ·	

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OC

Quality Control

October-22-12 3:17:25 PM Item ID: 647.1612 Accept *N900040100* Setup Start **Revision ID:** Item Name: Splice Plate Start Date: 22/10/2012 **Start Oty: 12.00** *12* **Cust Item ID: Required Date: 05/11/2012** Rea'd Otv: 12.00 Customer: Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Reject Plan Accept Reject Insp. Work Center ID Description Oty **Run Hours** Code Oty Number Stamp 160 QC5- Inspect part completeness to step on W/O 0.00 *160* OC Memo Quality Control 170 0.00 *170* 16 Ø Ø A SprayPaint 0.00 Memo **Spray Painting** PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 3) CARDINAL 4860-50 PRIMER BATCH: 123693 180 QC14- Inspect Spray Paint 0.00 *120*

0.00

Memo

										DQA:	Date:	•
NCR: \	res / No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE	QA Closed:	Date:	
										QA Closed.	Date	
Work Orde	er:				DISPOSITION	٠			AGAINST DE	PARTMENT,	/PROCESS	·
					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.				Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	1	re/Packaging	Other
NCR N	No				Work Order Update			Large Fab	Composite		Supplier	
		_	,									
Root				1	ption of work order update		Initial	1	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								Í				
Equip/Tooling	_											
Operator												
Material							i f w					
Setup							ar			:		
Other												
Process												
Supplier												
Training												
Unapproved												
						AUI	T CATE	GORY				
Landi	ng Gear				General		_			_		_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
i	Centre N	ot Conce	ntric to	O/S.	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
[Crushed	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
« ' <u> </u>	Cuffs				Contamination		Mainte	nance		Part Moved	<u> </u>	_
	Heat Tre	at			Countersink		1 Mislabe	led		Positioned V	Vrong	

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Page 4

October-22-12 3:17:25 PM Item ID: 647.1612 Accept *N900040100* Setup Start **Revision ID:** Item Name: Splice Plate **Start Date:** 22/10/2012 **Start Otv:** 12.00 **Cust Item ID: Required Date:** 05/11/2012 Reg'd Oty: 12.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Un/ Tool ID Tool# Reject Plan Reject Accept Insp. Work Center ID Description Oty Otv **Run Hours** Code Number Stamp 190 Identify as per dwg & Stock Location: *100* Packaging 0.00 Memo Packaging ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV*** 200 QC21- Final Inspection - Work Order Release 0.00 *200* QC 0.00 Memo Quality Control

12-12-2

												DQA:	Date:	
NCR:	Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
									,			QA Closed:	Date:	
Vork Ord	er.						DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
Part I							Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	NCR No Work Ord						Work Order Update		·	Large Fab	Composite	1	Supplier	
Root					Descr	ript	ion of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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Landi	ng (Gear					General							
		Bending				B	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	B	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				E	Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/C	Crimped.			B	Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				c	Contamination		Mainte	enance		Part Moved		
		Heat Treat	t				Countersink		Mislabe	eled	Γ	Positioned V	Vrong	
		Inspection	Strip in	Tube		_]c	Cut Too Short		Misread	i d	Γ	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Orill Holes		Offset		_	_			
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
		Turning Se	equence			F	inish		Out of s	Sequence				
		Wave/Twi	ist in Tub	oe -		F	olio		Outside	Dimensions				

Picklist Print

October-22-12 3:17:29 PM

Work Order ID: 92068

92068

Parent Item:

647.1612

647 1612

Parent Item Name: Splice Plate

Start Date: 22/10/2012

Required Date: 05/11/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.090		Purchased	No			110	sf	48.0000	0.0322	Q.4 067 37	·		
M2024T3	S 090								**	0.5			Jur-11-1

2024-T3 .090 sheet

Location	Loc Qty	Loc Code	
MAT022	48		
123287	48		123287

NCR:	Yes	/ No					WORK ORDER NON-C	10:	NFORM	MANCE / UPD	ATE	DQA:	Date:	
										•		QA Closed:	Date	
Vork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part	Part No. NCR No. Root Des						Rework Scrap Use-as-is Work Order Update		Machining Small Fa		Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Des	crip	otion of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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		Cracks			Ì		Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.		ľ		Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved		_
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube			Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset			_		
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration				
		Turning S	equence				Finish		Out of S	Sequence				
		Wave/Tw	ist in Tub	e			Folio		Outside	Dimensions				

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NOTES: MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2. COLOR BLACK: CARDINAL 4866-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377 J TYPE I CLASS N 4. DEBURR AND BREAK ALL SHARP EDGES SHOPLOY IDENTIFY IAW MPP-120 REITPN 10 (7) 4 PL ENGINETE: G UNCONTROLLED COPY SUBJECT TO AMEND: 41 N WITHOUT NOTICE -6 3 PL WORK ORDER MLJ 92068 MLJ 12-10-22 6 PL (5) 2 PL (3)-3 PL(9) 8 PL (8) 9 601.2989 SCREW 601.2980 NUTPLATE RIVET 647.1602 SHOWN EXPLODED 7 601.1900 NUTPLATE 6 601.2973 LOCKNUT 5 601.2764 WASHER 4 647.1613 DOUBLER 3 647.1612 SPLICE PLATE 2 647.1611 WIPER DEFLECTOR, AFT 647.1610 WIPER DEFLECTOR, FWD 647.1601 SHOWN EXPLODED 647.1602 DOUBLER ASSY .1602 .1601 FIND PART# DESCRIPTION PARTS LIST QTY

M\$27039-0812 CCR26459-3-04 4321039-3 44521040-08 NAS1149ENB32E 2 647.1601 WIPER DEFLECTOR ASSY, AFT MATL SPEC. APICAL INDUSTRIES

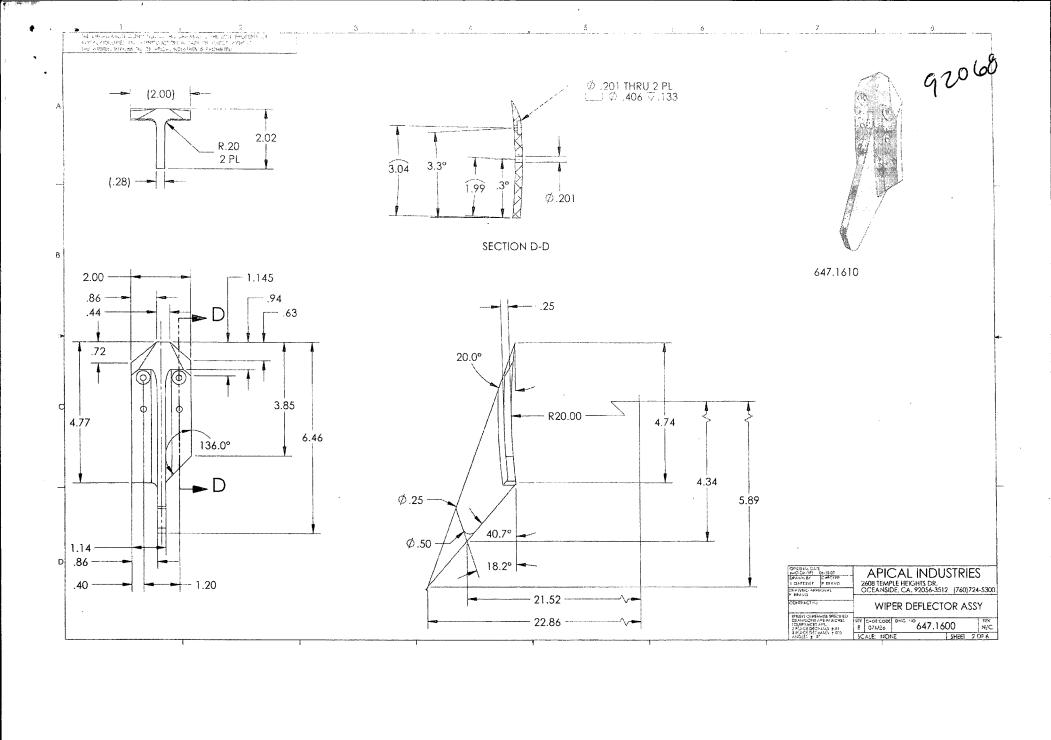
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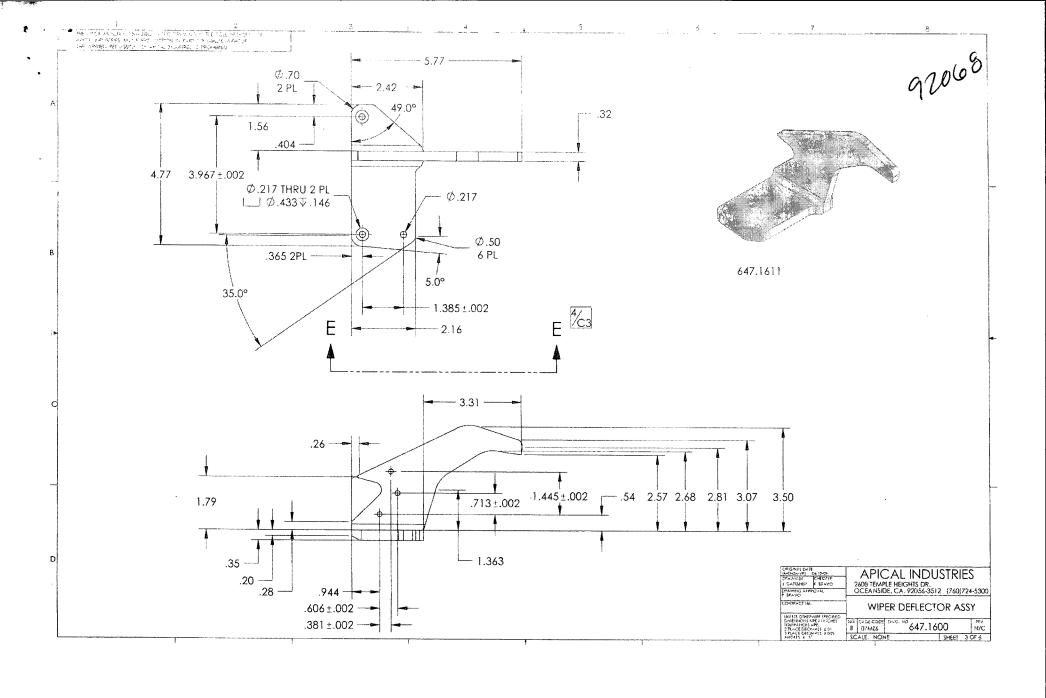
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 [760]724-5300

WIPER DEFLECTOR ASSY

SEE CAGE CODE DAG NO. 8 07/MZ6 647.1600

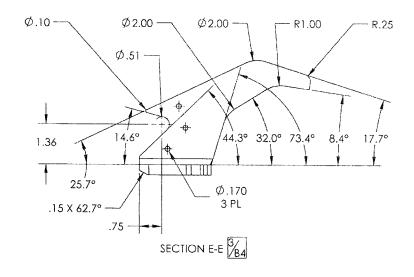
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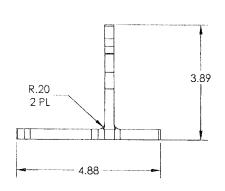


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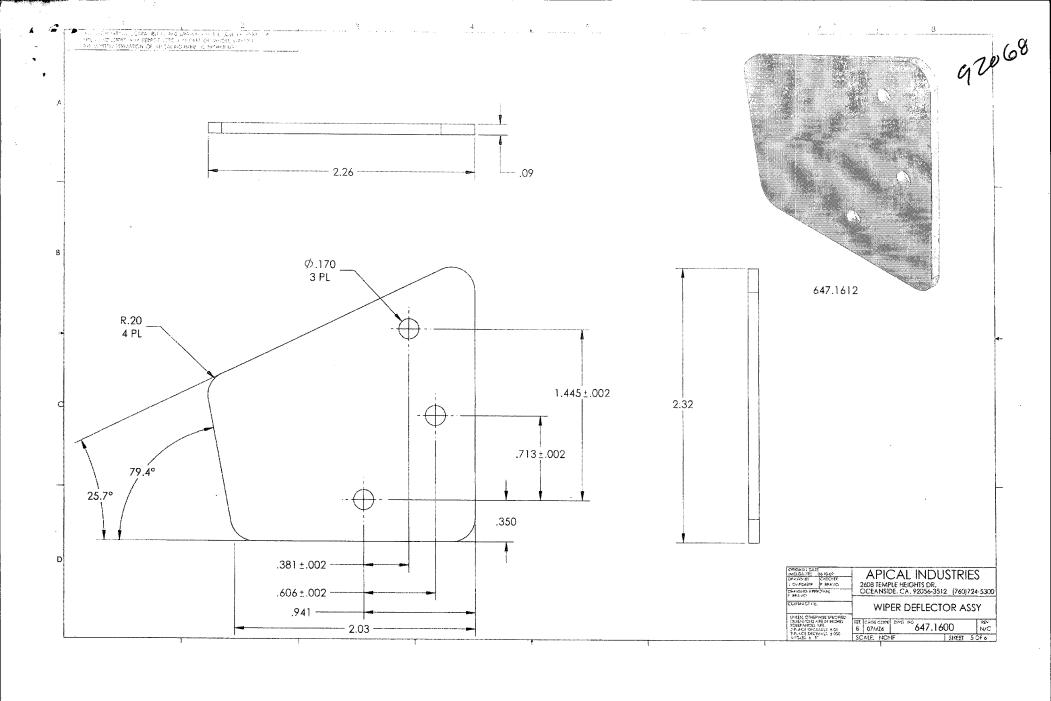


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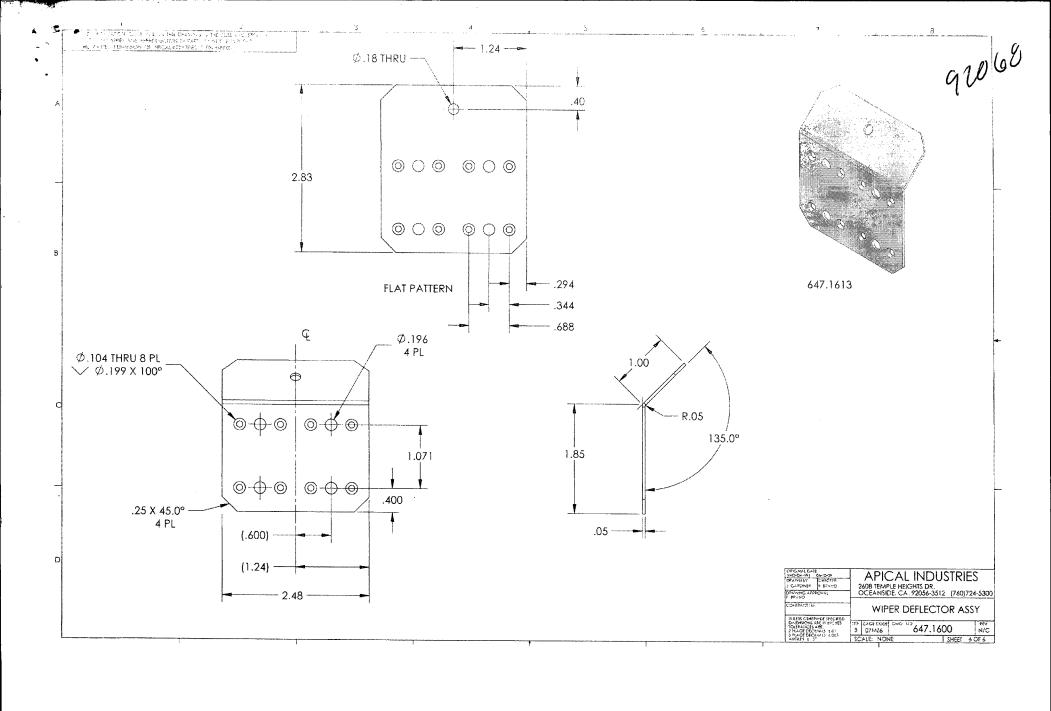


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DART AEROSPACE LTD	Work Order:	92068
Description: Splice Plate	Part Number:	647.1612
Inspection Dwg: 647. 1600 Rev: wc		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.170°	40.005"	0.170"	<u> </u>		U	Producers
0.090"	4-0000	0.090"	-	1	7	
2.26"	11-00010"	2.261"	_		<i>V</i>	
a.3a"	41-0,010	2.321"			V	
0.381"	11-0.010" 11-0.008"	0.381"	_		V	
0.606"	t/- 0000°	0,606"	<u>ب</u>		V	
0.941"	th 0.005"	0.942	~		V	
2.03"	11-0.010"	2.03"	-		V	
0.350	1/-0.005"	0.351"	_	2	. V	
O.713"	11-0-002"	0.713"	_		ν	
1.445	H 0.002"	1,445"	_		U	
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			DAS			

Measured by: Jm	Audited by:	69-0	Preliminary Approval:	
Date: 12-11-1	Date:	12/101	Date:	

			<u>.</u>	7		
Rev	Date	Change			Revised by	Approved
E	10.04.14	Added preliminary approval		d .	KJ	

\$ 10.04.15

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18338

Purchase Order Date 11/6/2012 PO Print Date 11/19/2012

Page Number 1 of 1

Order From:

VC-ATG001

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 **CANADA**

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607 Net 30

Terms Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line	Nbr Reference Revision ID Vendor Part Numbe	Description/ Mfg ID	Req Date/ Taxable Un	Req Qty/ ait of Measure	Ship Method	Unit Price	Extended Price
1	91440	347-0210 Rail	11/14/2012 Yes.	46.00	Dart Truck	\$8.8300	\$406.18
		Special Inst:	FINISH: HARD BI IAW MIL-A-8625,	and the second s			
2	91801	647.1713 Spacer	11/14/2012 Yes	14.00	Dart Truck	\$8.8300	\$123.62
		Special Inst:	Same as above				
3	92068	647.1612 Splice Plate	11/14/2012 Yes	12.00	Dart Truck	\$8.8300	\$105.96
		Special Inst:	Same as above				

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES

PO Total:

Change Nbr:

2

Change Date:

11/19/2012

\$635.76



A:T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62067

Date: 22-Nov-12

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

ms	*.	Ship Via		
Quantity	Description			
1 lot	Part: ASST		Rev:	
	46 PCS 347-0210 14 PCS 647.1713 16 PCS 647.1612			
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120721	PO: PO18338	Line:	
		· · · · · · · · · · · · · · · · · · ·	Line.	
	Certificate of Con	formance		
	A.T.G. Industries certifies that all items i with all requirements, specifications and	in this shipment are in co drawings referenced in t	nformance he purchase order.	
	ISO 9001 : 2008 REG ATG SALES-2010 TE	ERMS APPLY		
	CERTIFIED SIGNATURE :	, 		
	RECEIVER SIGNATURE :			
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